

Date: Friday, 9/1/2006 12:17:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	: 28408		
Estimate Number	: 10834		
P.O. Number	: N/A	Part Number	: D29332
This Issue	: 9/1/2006	Drawing Number	: D2933 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 28263	Material	: N/A
Written By	: <u>SA 06.09.01</u>	Due Date	: 9/20/2006
Checked & Approved By	: <u>SA 06.09.01</u>	Qty:	6 Um: Each
Comment	: Est: B 0006.26 New DWG rev (mpp 2069) EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: 25344

SA

6

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

SA 06.09.10

6

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 06.09.11

6

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 06.09.10

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SD Date: 26/02/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:17:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 28408

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/09/12

6

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ml

06 09 14

6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06 09 18

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/09/19

6

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5F350*

6 06/09/19

6

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP

06/09/19

6

Job Completion



W 06-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	28408
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B		Page 1 of 1	

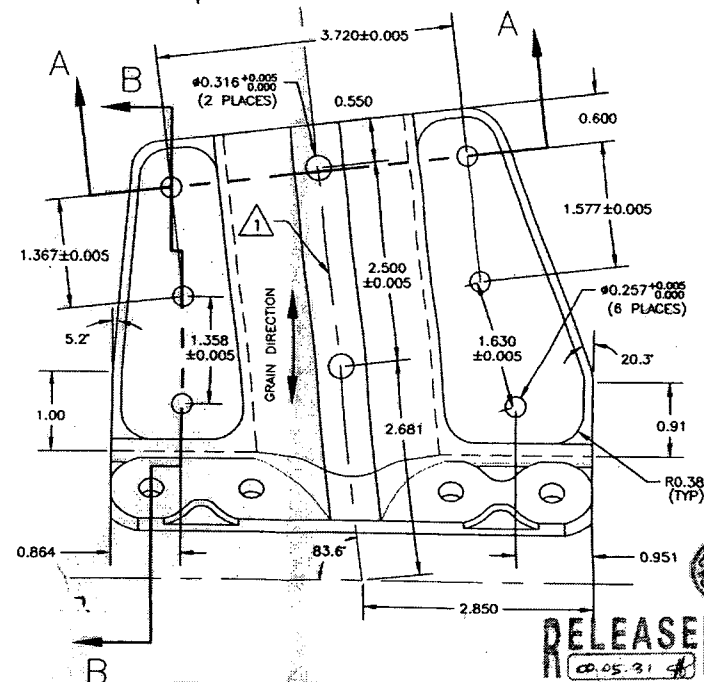
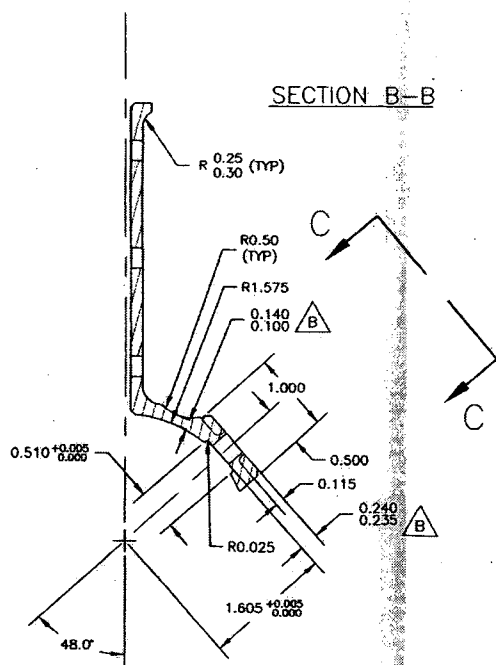
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.121	.121	.122		
B	0.100	0.140		.121	.120	.126	.121		
C	0.100	0.140		.129	.127	.125	.128		
D	0.210	0.230		.225	.225	.223	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515							
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.239	.238	.238	.239		
N	0.100	0.140		.124	.124	.124	.123		
O	0.540	0.560		.545	.546	.547	.549		
P	0.490	0.510		.499	.499	.498	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.250	.251	.250		
T	0.100	0.180		.145	.145	.145	.145		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.125	1.145		1.135	1.135	1.134	1.134		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06/09/10






Audited by:	JML
Date:	06/09/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN 	DRAWN BY 	 DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 	APPROVED 	
DATE	00.05.29	DRAWING NO. D2933 TITLE SADDLE INSIDE REV. _____ SHEET 1 OF _____ SCALE _____

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO.
D2933

REV. E

SHEET 1 OF 1

TITLE	SADDLE INSIDE
-------	---------------

SCALE
2:3